

Date: Monday, 10/30/2006 4:15:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	: 29232		
Estimate Number	: 10833		
P.O. Number	: <i>N/A</i>	Part Number	: D29331
This Issue	: 10/30/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2933 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>MA</i> Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28860	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/30/2006 Qty: 8 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: B00.66.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	7075-T7351 2X6X6.25
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: *B23343*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number. ✓
 1-Inspect part number and batch number are programmed correctly. ✓
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ✓
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ✓
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ✓
 5-Deburr ✓ *ml / SD 06.11.15*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet *ml 06.11.17*

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET *ml / SD 06.11.15*

W/O: <u>2</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DS Date: 06/11/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.11.15	Z	Tool radius for flange pocketing is R0.188 instead of R0.35.	UP 06.11.15 per QSI 042	Use R0.188 per marked up dwg. See attached DS email	SD 06.11.15	DS 06/11/15	UP 06.11.15 per QSI 042	DD 06/11/15

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:15:19 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 29232

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/11/22

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y 06/11/24 x 8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y 06/11/27 x 8

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PU 4/4/27 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5473

PU 4/4/27 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP 4/11/28 (8)

Job Completion



C 206/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29232
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.126	.125	.125	.125		
B	0.100	0.140		.127	.125	.125	.125		
C	0.100	0.140		.113	.120	.121	.122		
D	0.210	0.230		.220	.220	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.499	2.499	2.499		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		.120	.120	.119	.120		
O	0.540	0.560		.550	.551	.551	.550		
P	0.490	0.510		.500	.508	.499	.499		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.253	.253	.253	.253		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.315	.315	.319	.319		
X	1.125	1.145		1.134	1.134	1.133	1.133		
Y	1.565	1.585	DT8685 A/B	1.570	1.571	1.575	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	06.11.15

Audited by:	J.L
Date:	06/11/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	

DART AEROSPACE LTD	Work Order: 29232
Description: 206 Saddle, Inboard, Left side	Part Number: D2933-1
Inspection Dwg: D2933 Rev. B	Page 1 of 1

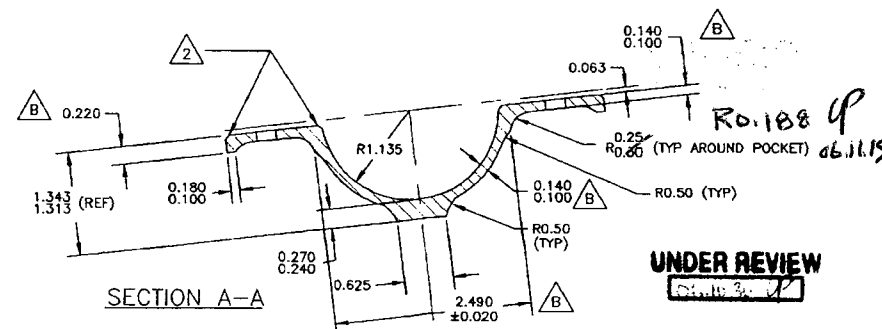
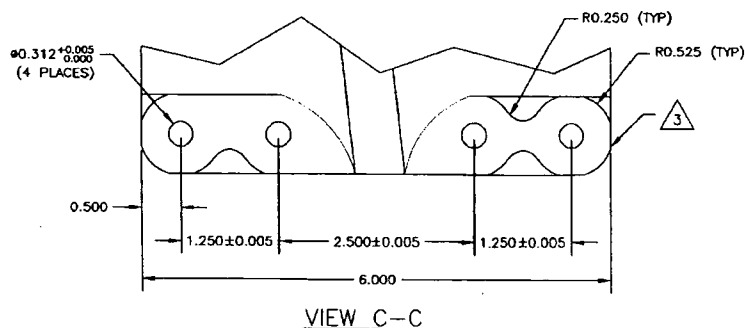
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.130	0.130	0.128	0.128		
B	0.100	0.140		0.130	0.131	0.131	0.128		
C	0.100	0.140		0.129	0.127	0.127	0.130		
D	0.210	0.230		0.217	0.218	0.219	0.215		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.256	1.250	1.256		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.576	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.237	0.238	0.238		
N	0.100	0.140		0.118	0.119	0.120	0.117		
O	0.540	0.560		0.552	0.552	0.551	0.547		
P	0.490	0.510		0.502	0.502	0.502	0.502		
Q	3.715	3.725		3.721	3.721	3.718	3.720		
R	2.470	2.510		2.499	2.490	2.495	2.492		
S	0.240	0.270		0.255	0.254	0.254	0.255		
T	0.100	0.180		0.143	0.140	0.140	0.138		
U	1.625	1.635		1.630	1.628	1.628	1.628		
V	1.362	1.372		1.368	1.366	1.366	1.366		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.133	1.133	1.132		
Y	1.565	1.585	DT8695 A/B	1.573	1.575	1.575	1.575		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SA / ml
Date: 06.11.15

Audited by: J.L
Date: 06/11/22

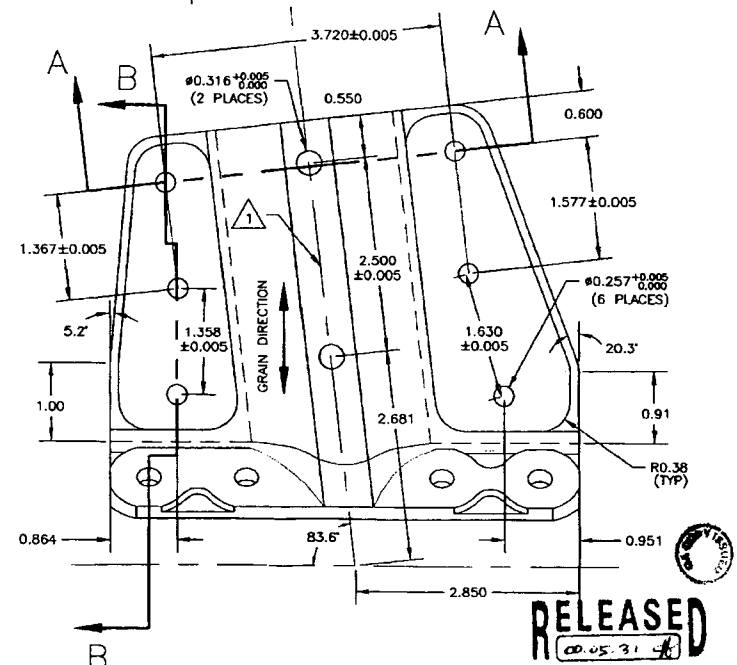
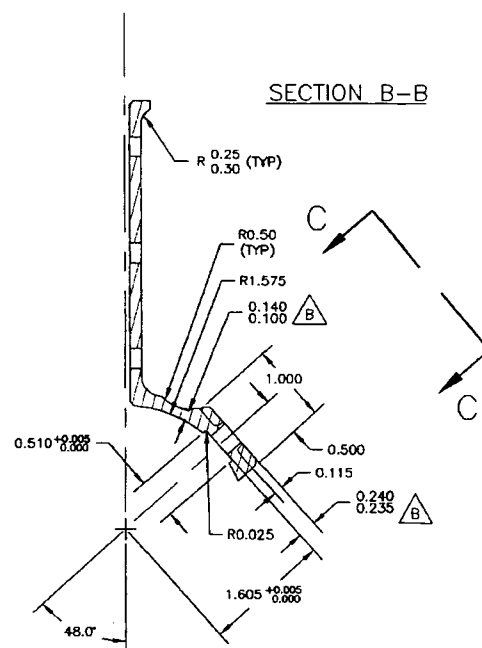
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



NO. 29238
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	00.05.29	TITLE SADDLE INSIDE
COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.		REV. B SHEET 1 OF 1 SCALE 2:3

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188 since the tooling has been changed long time ago, and apparently they have been machining those radiuses to 0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the changes.

Serge

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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